

# Work Order ID 83499

\*83499\*

Page 1

Thursday, April 19, 2012 10:22:55 AM

Item ID: D2010-104 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Mirror Arm 369/500  
 Start Date: 4/19/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 4/27/2012 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: Q Date: 12-04-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2010	Rev D								

100

0.00

\*100\*

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727  
 Identify as D2010-104

6 0 FF  
 12-05-29

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Bend as per Dwg D2010 using bending Jig D2010-104T2  
 2- Deburr ends

6 FF  
 12-05-29

120

0.00

\*120\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1- flare before installing plug as per dwg D2010  
 2- Install D2057 plug as per Dwg D2010

6 FF  
 12-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

**Work Order ID 83499****\*83499\***

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Thursday, April 19, 2012 10:22:55 AM

Item ID: D2010-104

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Mirror Arm 369/500

Start Date: 4/19/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location 220

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/6/01 (6)12/6/01ML5 12/06/01

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, April 19, 2012 10:22:59 AM

Page 1

Work Order ID: 83499

\*83499\*

Parent Item: D2010-104

\*D2010-104\*

Parent Item Name: Mirror Arm 369/500

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.02.17New issueKJ/JLM  
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC  
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049

Purchased

No

100

f

265.6762

1.5

9.473684

\*M304TR0 500W 049\*

\*\*

6 FF 12-05-29

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT017

265.676218

111814

2.23

115010

109.254058

117598

3.97

119087

7.359

120633

142.86316

9.473684

D2057

Manufactured

No

110

Each

28.0000

1

6

\*D2057\*

\*\*

6 FF 12-05-29

Plug

Location

Loc Qty

Loc Code

GA

28

71888

8

75070

20

6

W/O:		WORK ORDER CHANGES					
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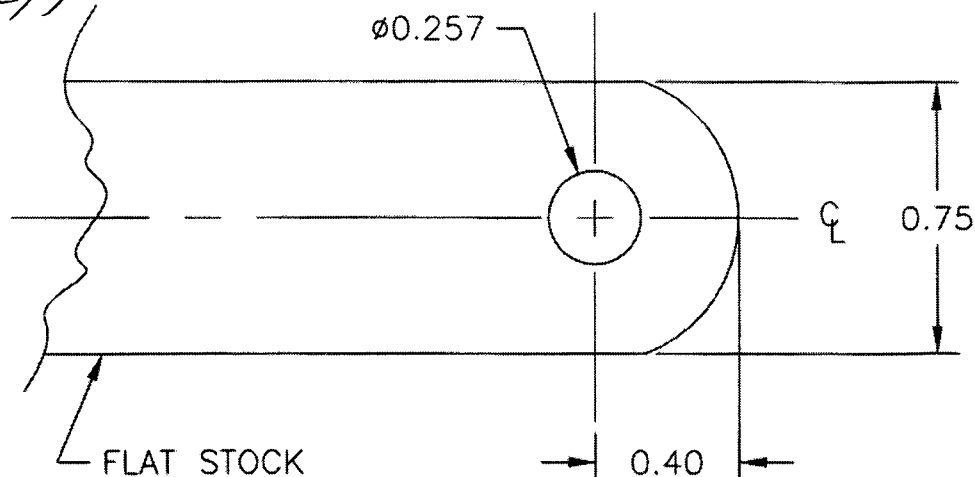
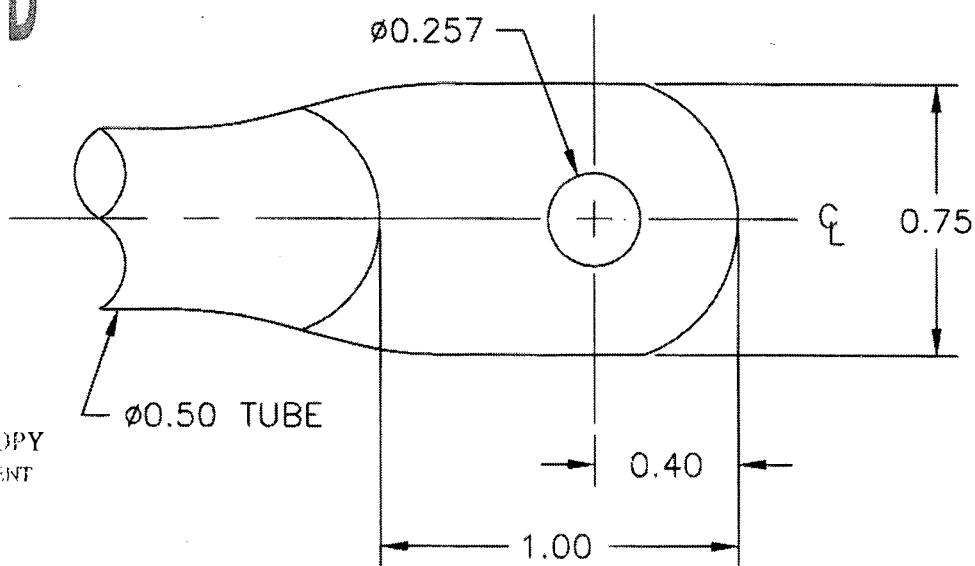


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#1P 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED  
98/03/06 KE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83499



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

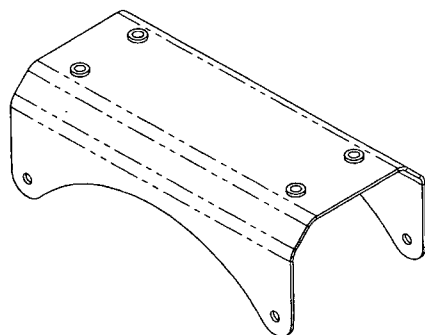
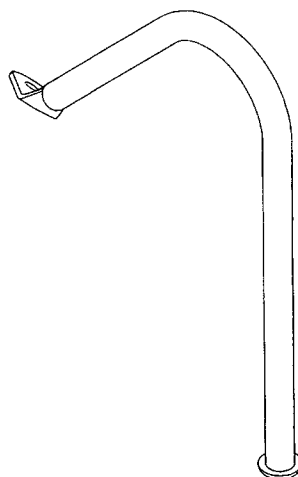
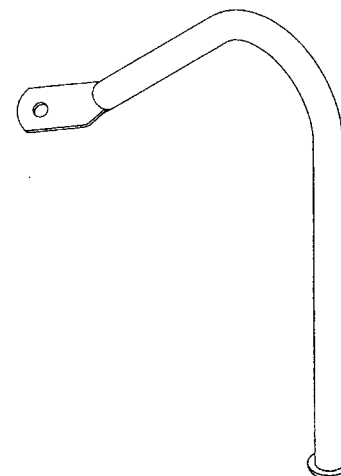
A

D

C

B

A

**D2010-101 MIRROR BRACKET****D2010-103 ARM****D2010-104 ARM**

83409

RELEASED  
08.06.10

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø 0.500 X 0.049 WALL WAS Ø 0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2010	SHEET 1 OF 4
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

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2

1

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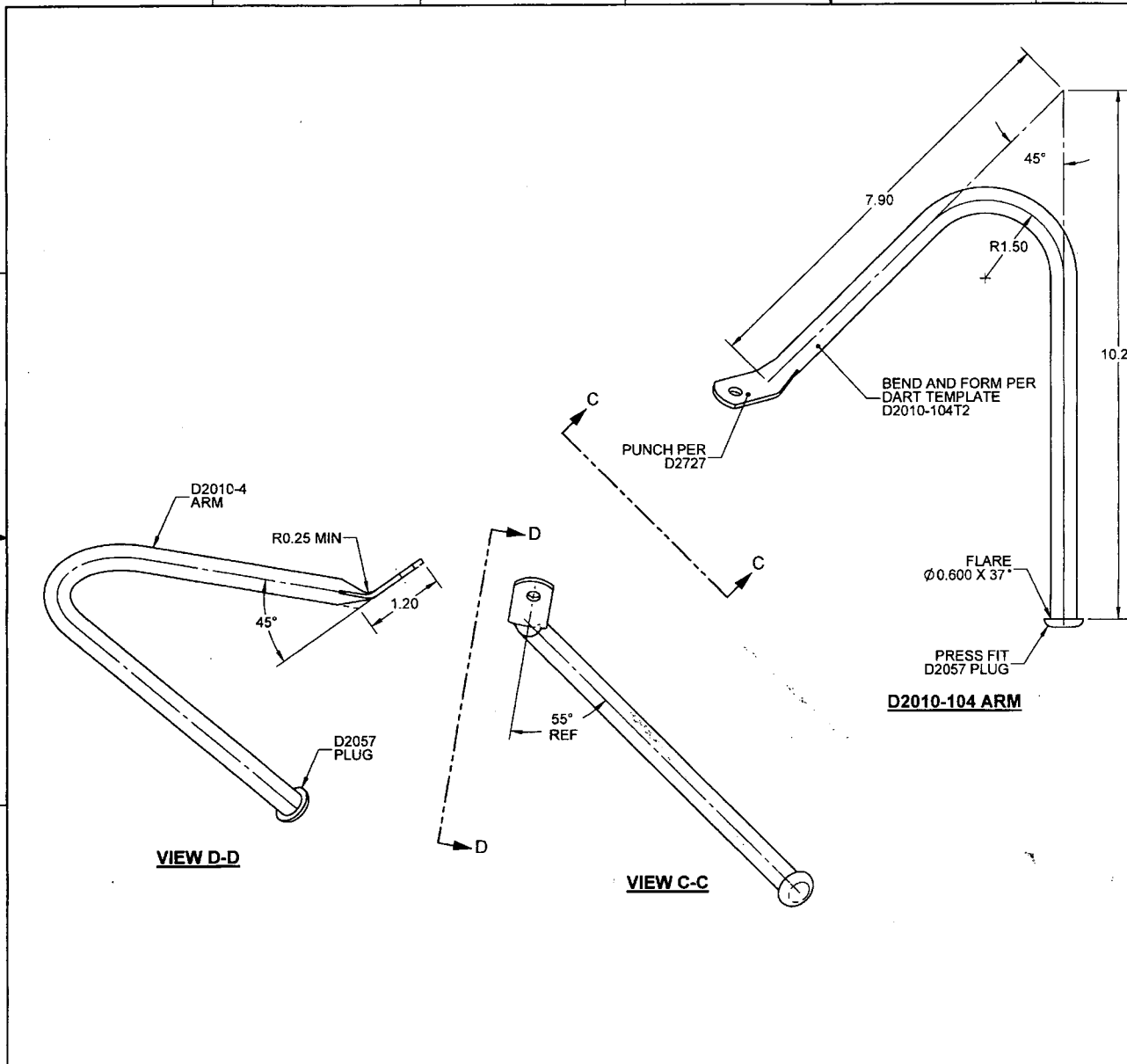
QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG

83499

RELEASED

- NOTES:
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\varnothing 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
  - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D2010	SHEET 4 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	MIRROR BRACKET	NTS
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